

Work Order ID 115510

115510

Page 1

April-02-14 11:15:32 AM

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLSDate: 14-04-02

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3391	I
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100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: HL & Dwg D3391 Rev: HL

****REMOVE STEADY REST AND MACHINIG MARKS****

1 ϕ KL
14-04-03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1 ϕ mm2
14/04/07

DAS
27
9-89

112

QC5- Inspect part completeness to step on W/O

0.00

112

QC

Memo

0.00

Quality Control

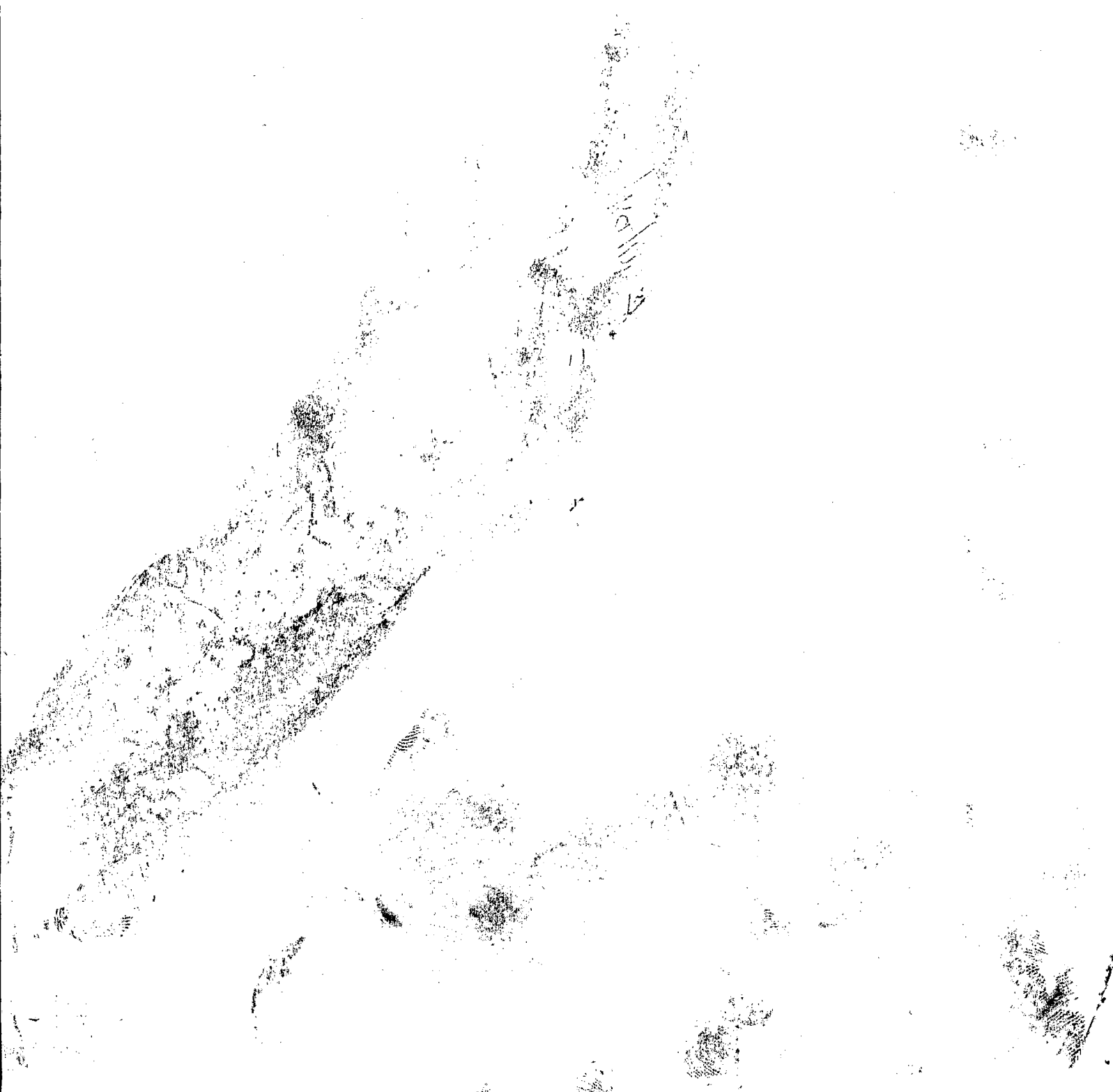
14/4/4

1

200
41
200

6-12-80

6-12-80



Work Order ID 115510

April-02-14 11:15:32 AM

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Page 3

Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DC 14/04/29

160

0.00

160

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DC 14/04/29

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS
03
9-89

DD 14-4-29

H-4.21

Work Order ID 115510

April-02-14 11:15:32 AM

115510

Page 4

Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 4/02/14 Start Qty: 1.00

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Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Deburr

8- Scribe batch # on fwd end

DC 14/05/22

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 Item Name: Aft Tube Assembly
 Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
210 *210* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							

SM
4/5/26

12 14/06/04

1 0 14/06/04

DAS
18
0-00

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Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

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Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
220	Skidtubes	0.00							
Skidtubes	<div><div>Memo</div><div>1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 129172 exp. date : 14/12/30 cure time 12hrs as per QSI0015</div><div>2- Grind crossbolts flush</div><div>3- Back drill using #9 drill</div><div>4- Touchup Magnabond</div><div>5- Deburr</div></div>								
230	QC5- Inspect part completeness to step on W/O	0.00							
230	QC	0.00							
Quality Control	Memo								

DC 14/06/04

DC 14/06/05

SMP
M/6/5

Work Order ID 115510

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 4/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
235									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								
240	White Gloss(Ref:4.5.1) per QSI005 4.3 Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:00 OVEN TEMPERATURE: 320 FINISH TIME: 2:30								
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							
Quality Control									

DAS
15
8-89

Work Order ID 115510

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115510

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Item ID: D3391-025

Accept

N900040100

Setup Start *NS1*

Revision ID:

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Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260		0.00							
260	HandFinishing					1x	0	lll	w/09/16
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 <u>N4129453</u> Sikaflex expiry date: <u>10/4</u> 3- INSTALL WEARPLATES AS PER DWG								
270	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89 14-9-16
270	QC	0.00							
Quality Control	Memo								
280	Identify as per dwg & Stock Location: <u>w/b</u>	0.00			D412-7412-043/13112196	1x	0	lll	w/09/16
280	Packaging	0.00							
Packaging	Memo								

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Item ID: D3391-025 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft Tube Assembly
Start Date: 4/02/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 4/16/14 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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290	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

290

QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control

14/9/17
MF
14-9-16

Picklist Print

April-02-14 11:15:34 AM

Page 1

Work Order ID: 115510

115510

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4095-047		Manufactured	No			260	Each	18.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4095-047

Wearpad Assembly

**

11/04/14

Location	Loc Qty	Loc Code
FP001	18	
102241	2	
108289	16	

D4095-049		Manufactured	No			260	Each	13.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4095-049

Wearpad Assembly

**

11/04/14

Location	Loc Qty	Loc Code
FP001	12	
109670	12	
FP002	1	
102216	1	

D6014-090		Manufactured	No			100	Each	69.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D6014-090

ALUMINUM EXTRUSION

**

Location	Loc Qty	Loc Code
LG003	69	
79742	17	
86063	52	

11/04/02

Picklist Print

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Work Order ID: 115510

115510

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

300.0000

4

4

D3670-4-200

Bushing

Location

Loc Qty

Loc Code

FG

10

87709

10

LG001

290

103880

39

109108

242

~~96240~~

9

D2646

Manufactured No

270

Each

75.0000

1

1

D2646

Aft Cap

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

71

103306

14

107857

1

110816

18

113830

38

April-02-14 11:15:35 AM

Shop Packet Print

Page 2

Picklist Print

April-02-14 11:15:35 AM

Page 3

Work Order ID: 115510

115510

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270 Each 1,420.000 2 2

D3672-1

Phenolic Washer

lll 4/09/14

Location

Loc Qty

Loc Code

FG	10
85222	10
ST060	1410
103845	4
112218	500
<u>113581</u>	500
93886	224
99099	182

<i>X 2</i>

ALS4-1032-130 AELS4-1032-130 Purchased No

260 Each 9,937.000 14 14

ALS4-1032-130

Rivnut

lll 4/09/14

Location

Loc Qty

Loc Code

FP001	9832
<u>M128649</u>	9832
ST279	48
M128211	48
st510	57
M126109	57

<i>KL4</i>

Picklist Print

April-02-14 11:15:35 AM

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Work Order ID: 115510

115510

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225 Purchased

No

270

Each

1,490.000

8

8

AI S4-1032-225 *ALH57-1032-225*

all reloaded

Rivnut

Location

Loc Qty

Loc Code

FG	30	
M127028	30	
FP001	1000	
M128649	1000	<i>✓ 8</i>
ST280	426	
M127028	10	
M128179	416	
st555	34	
M127092	34	

AN3C4A

Purchased

No

270

Each

2,208.000

6

6

AN3C4A

all reloaded

Bolt

Location

Loc Qty

Loc Code

FG	20	
122814	20	<i>M124520</i>
ST350/513	1000	<i>✓ 6</i>
M128606	1000	
ST512	3	
124221	3	
ST513	1185	
125388	122	
M127410	1	
M127832	62	
M128634	1000	

April-02-14 11:15:35 AM

Shop Packet Print

Page 4

Picklist Print

April-02-14 11:15:35 AM

Work Order ID: 115510

115510

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 270 Each 705.0000 4 4

AN3C5A

Bolt

**

all 4/02/14

Location

Loc Qty

Loc Code

FG 5
122800 5
ST350 700
M128057 700

11124413

xd

NAS1149C0332R Purchased No 270 Each 9,644.000 10 10

NAS1149C0332R

WASHER

**

all 4/02/14

Location

Loc Qty

Loc Code

GA 1005
125654 1005
ST292 4968
m128591 4968
st510 3671
m126319 61
m127306 2500
m127410 1084
m127831 26

KLQ

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
--	--	---	---

DART AEROSPACE LTD		Work Order:	115510
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: I	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

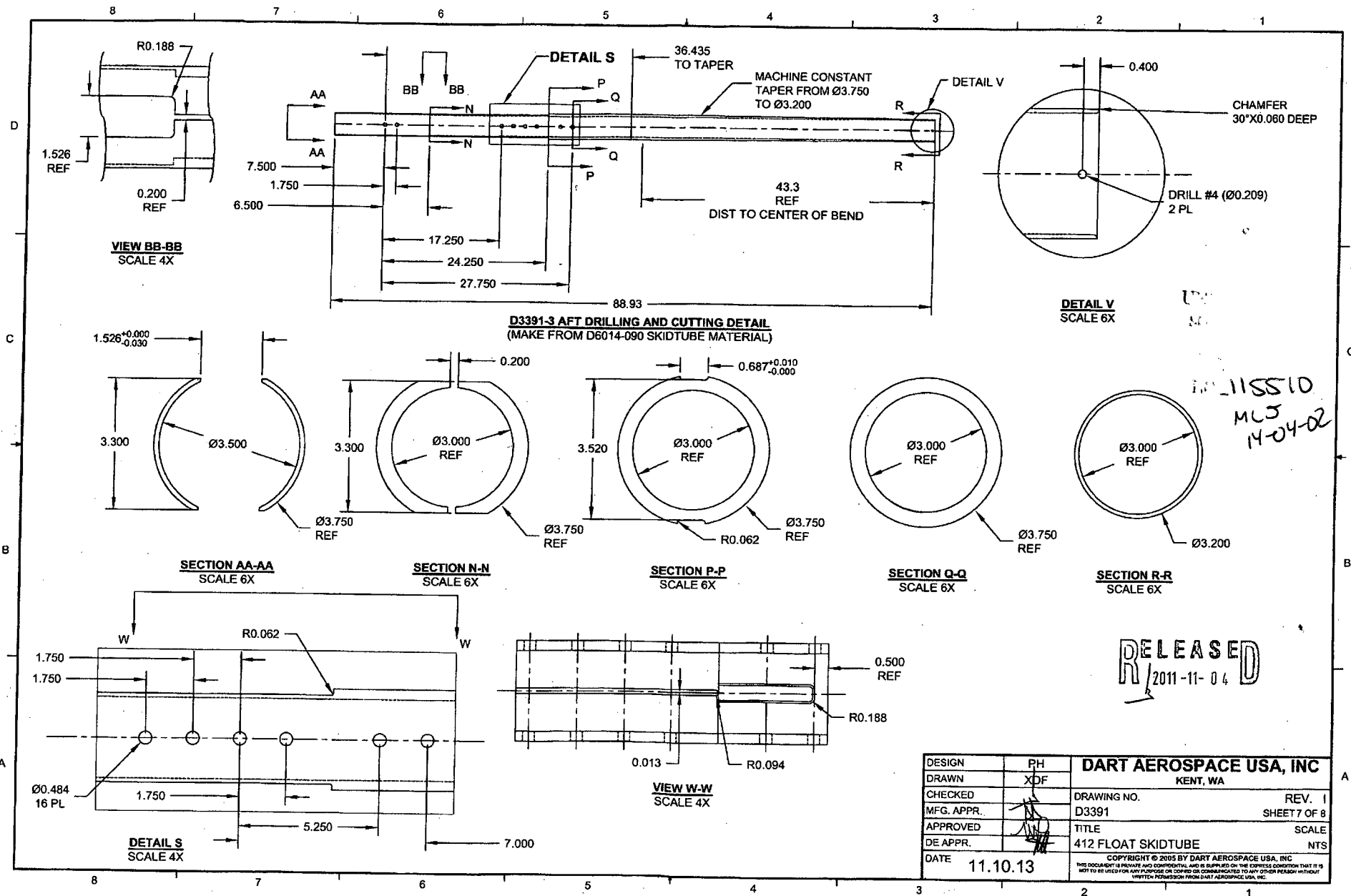
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	LG-25
3.500	+/-0.010	3.503	✓		vern	CNC-08
Ø3.200	+/-0.010	3.201	✓			
Ø3.750	+/-0.010	3.750	✓			
30° x 0.060 chamfer	+/-0.010	30° x 0.063	✓		↓	
88.93	+/-0.030	88.93	✓		tape	LG-25



Measured by: <i>mm</i>	Date: 14/04/06
Audited by: <i>1</i>	Date: 14/4/19

HAAS Section						
1.526	+0.000/-0.030	1.510	✓		Vern	ML-06
7.500	+/-0.010	7.500	✓		"	
27.750	+/-0.010	27.750	✓		1/4 tape	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.300	✓		Vern	
0.200	+/-0.010	.200	✓		"	
3.520	+/-0.010	3.522	✓		"	
0.687	+0.010/-0.000	.689	✓		"	
R0.062	+/-0.010	R.062	✓		R-L	
Ø0.484	+0.005/-0.001	Ø.485	✓		Vern	

Measured by: <i>mm</i>	Date: 14/04/27
Audited by: <i>FK</i>	Date: 14/04/28

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O-D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	



DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

